

Split -1

Work Order ID 126746 -1

126746

Page 1

Item ID: D5123-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp Cushion

Start Date: 11/24/2014 Start Qty: 100.00

~~*100*~~ 96

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 100.00

100 96

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-11-24 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5123	B

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Mill as per DWG

DWG REV: _____

2-Deburr as required

100

Ø

J.C.L.

14/12/22

DAS

44 14/12/22

9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

100

Ø

J.C.L.

14/12/22

DAS

44 14/12/22

9-89

(4 Taken for
R.D. 5319)

PTO

DQA:

Date: 15/01/26



QA Closed: 8/09/14

Date: 15/11/13

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 126746	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. 05123-1		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 15-4530		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.12.23	100	100	RO.032 IS RO.015 (C8-1)	A.P.	ACCEPTABLE AS IS	J.C.L.		
Doc/Data					14.12.23		14/12/23		
Equip/Tooling ☒									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
				RC custom tool was not made properly		fix cutter and inspected by QC.	14/12/23	14/12/23	14-12-23

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☒ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 126746

126746

Page 2

Monday, November 24, 2014 10:32:32 AM

Item ID: D5123-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Cushion
Start Date: 11/24/2014 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 11/24/2014 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							DAS 08 9-89
			B. a 14/12/23 96 ϕ (the 4 missing are in split #2)						
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG55</u> Memo	0.00 0.00				96			15-01-08-CN
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ		15-01-08	

Handwritten signature/initials

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
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☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Picklist Print

Monday, November 24, 2014 10:32:35 AM

Page 1

Work Order ID: 126746

126746

Parent Item: D5123-1

D5123-1

Parent Item Name: Clamp Cushion

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 14/08/08 JLM VERIFIED BY:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4287-1		Manufactured	No				f	11.9500		44			
---------	--	--------------	----	--	--	--	---	---------	--	----	--	--	--

D4287-1

Uhmw U-Channel

J.C.L.

Location

Loc Qty

Loc Code

ST479a

11.95

122562

0.51

125701

11.44

127169

11.44

14/12/10

30.63

14/12/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

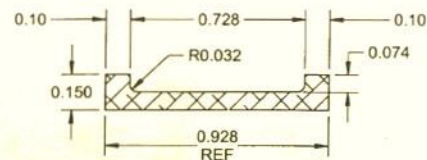
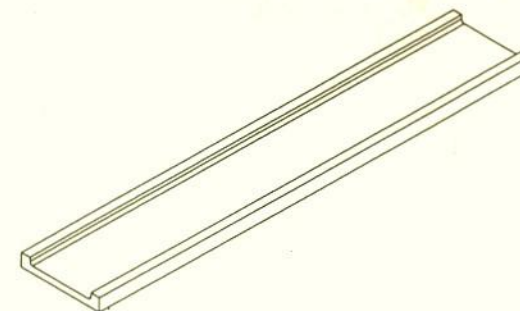
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

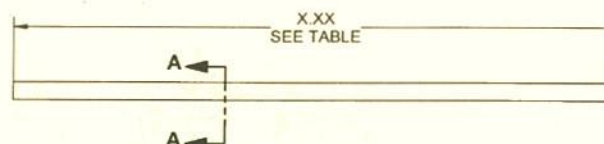
FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
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			☐ Wrong Stock Pulled
			☐ Other

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SECTION A-A 
SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 126746 M15
14-11-24

RELEASED
2014-10-08

MD

- NOTES:
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 - 7) WEIGHT: LESS THAN 0.01 lbs

APPROVED

B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.06
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP	DRAWING NO. D5123 REV. B	
CHECKED	ML	SHEET 1 OF 1	
MFG. APPR.	JLM	SCALE	
APPROVED	MP	TITLE CLAMP CUSHION NTS	
DE APPR.	DS	DATE 14.08.19	
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